

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002838**Date Inspected:** 04-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at the skin plates splices weld joints #ESD1-SA77 A/E-45B, ESD1 SA294 A/G-12B and ESD1-SA294 A/G-4B. The QA inspector performed 10 % UT at random locations. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL_6027 generated on this date.

The QA inspector performed UT at the completed joint penetration at the side plates splices weld joints # SEG-015A-007 (Bottom plate D6 to side plate C5) and 008 (Bottom plate D6 to side plate E7), for the lift 3B-West. The QA inspector performed approximately 20 % UT at random locations. The QA inspector found a class A rejectable indications thru the entire length on weld joint # 7 and 8. The class A indications found on the weld joint 008 appeared to be weld geometric from the ceramic backing weld reinforcement (this areas where rejected on the entire length by ZPMC. The QA inspector did not perform a complete assessment of the joint because the QA inspector was aware that ZPMC had already assessed the weld joint and want to confirm ZPMC findings). The QA inspector brought to the attention of ZPMC representative Fu Yu Hong and ABF representative Peter Saw of the QA findings. The QA inspector requested to go over the indications with ZPMC technicians at the areas tested by the QA inspector to assess ZPMC findings in specific locations. ZPMC agreed. ZPMC technician and the QA inspector postponed the meeting due to schedule changes on the ZPMC's marine transportation on this date.

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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo
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Quality Assurance Inspector

Reviewed By:	Cuellar,Robert
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QA Reviewer
